

Date: Friday, 18/07/2008 10:50:31 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT
Job Number :	40617		
Estimate Number :	10204		
P.O. Number :		Part Number :	D21997
This Issue :	18/07/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2199 REV. E1
First Issue :	11	Project Number :	N/A
Previous Run :		Drawing Revision :	E1
	Type :	Material :	
	SMALL /MED FAB	Due Date :	15/08/2008
Written By :		Qty:	5 Um: Each
Checked & Approved By :	JLD 08.7.18		
Comment :	Est:A 02.06.10 New Issue NG/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 1.3125 f(s)/Unit Total: 6.5625 f(s)

Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall

(M304TR0750W049)

Batch No: M107518 (3)

M108498 (2)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC

Punch per Dwg. D2199 and Spec Control Dwg D2638

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
400°F
9:45

M. L 08/08/05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2197-7 PAR #: N/A Fault Category: Prod/Finishing NCR: (Yes) No DQA: D Date: 08/06/04
D212-601-042 QA: N/C Closed: D Date: 08/08/08

NCR: <u>40617</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
8/8/05	5.0	Durkin Qc3 Powder coat inspection it was found on 2 parts that there was some die/markings that came through the powder coat. P.C. Parts were not cleaned enough.	<u>[Signature]</u> <u>Qc3</u>	Scuff with 320 grit sand paper till raw mat is showing. clean with acetone Re Powder coat as per QSTC05	<u>[Signature]</u> 08/08/05 <u>m-p</u> 09/08/05 <u>m-p</u> 08/08/05	<u>S</u> 08/08/05	<u>[Signature]</u> 08/08/05	<u>C</u> 8/8/05

NOTE: Date & initial all entries

Date: Friday, 18/07/2008 10:50:31 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 40617

Part Number: D21997

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 08/08/05

(5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *272*

8/8/5

(5x)

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/06/08

Job Completion



U 08.08.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

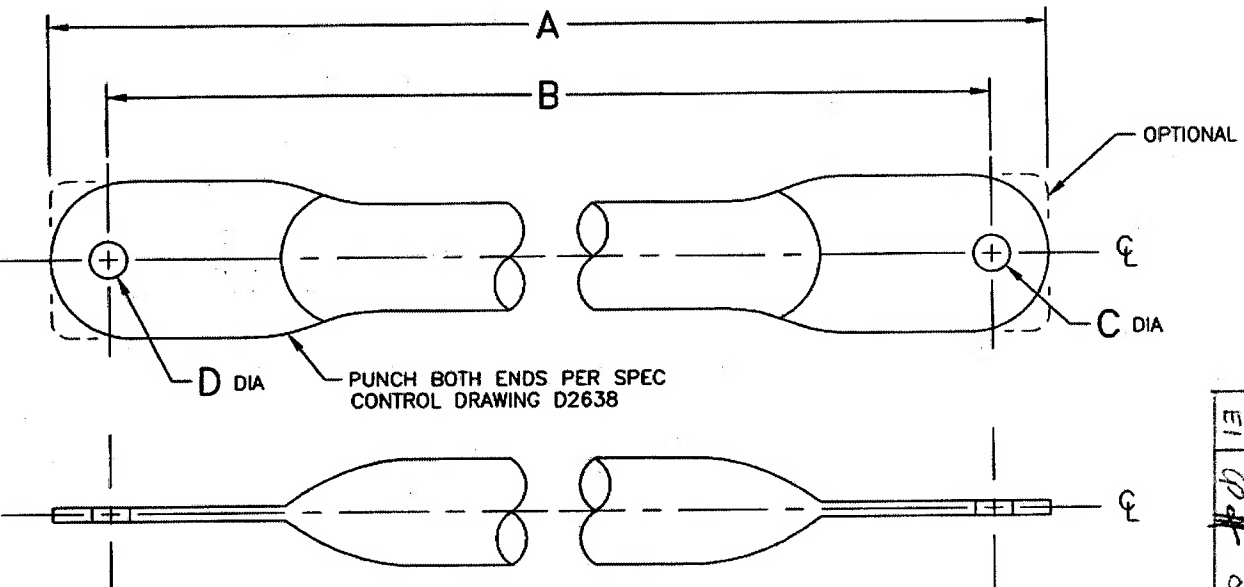
NOTE: Date & initial all entries

DART



RELEASED
48.05.05 EE

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
DATE 98.04.28	DRAWING NO. D2199	TITLE STRUT DETAILS	SHEET 1 OF 1
A	1993	NEW ISSUE	SCALE NTS
B		ADDED -11, -13, AND -15	
C		ADDED -17 AND -19	
D		ADDED -21	
E	98.04.28	ADDED -23 AND -25 PER TSR A565M ADDED TEMPLATE & SPEC CTRL DWG REDRAWN IN CAD	
E1	02.03.22	ADD FINISH	



	A	B	C	D
D2199-1	18.30	17.50	0.257	0.257
D2199-3	5.80	5.00	0.257	0.257
D2199-5	22.64	21.84	0.257	0.316
D2199-7	14.74	13.94	0.257	0.257
D2199-9	16.52	15.72	0.257	0.257
D2199-11	23.60	22.80	0.257	0.316
D2199-13	15.96	15.16	0.257	0.257
D2199-15	17.57	16.77	0.257	0.257
D2199-17	28.05	27.25	0.257	0.316
D2199-19	18.90	18.10	0.257	0.257
D2199-21	10.80	10.00	0.257	0.257
D2199-23	26.18	25.38	0.257	0.316
D2199-25	19.93	19.13	0.257	0.257
D2199-27	27.34	26.54	0.257	0.316
D2199-29	21.11	20.31	0.257	0.257

(B)(B)(B)(C)(C)(C)(E)(E)
} # 00.10.13
(P 00.10.13)

- NOTES:
1. MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER
 2. MATERIAL: AISI 304/316 STAINLESS STEEL TUBE Ø0.750 x 0.049 WALL
 3. FINISH: POWDER COAT. WHITE (4.3.5.2) PER DART QSI 005 4.3.5.2

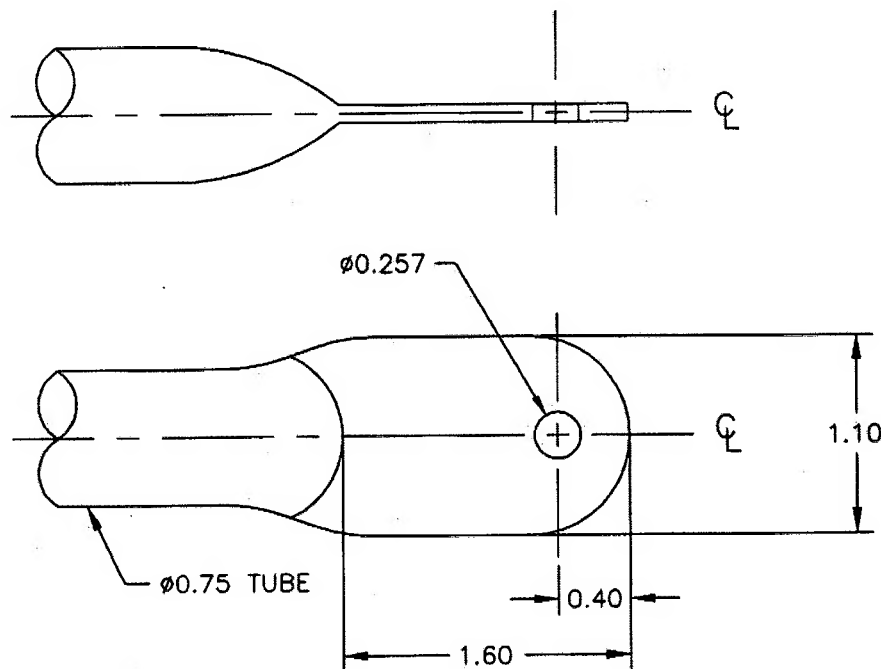
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WITHOUT NOTICE
WORK ORDER
NO. 40617



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DMS	APPROVED [Signature]	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28	TITLE PUNCH DT8117 SPEC CONTROL		SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED
98/09/05 KE

SPECIFICATION CONTROL DRAWING
FOR PUNCH DT8117



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